



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB6872880
Job Sheet 196895



Part No: RB6872880 Job Qty: 2 pcs

Part Name: Compressor Mounting Inserts Checking Fixture



Part Weight: 0 lbs Status: New Priority: Medium
Job Created: 6/24/19 Job Tracking No:
Due Date: 7/29/19 Created By: Kimberley Guerin
Type: Stock Description:
Note: DWG RB6872880 Rev 0 IPP Rev. A 19.06.19 New issue DP Verify DD
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	2 pcs	7/29/19		0.00	0.00	Purchasing - 1		
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	2 pcs	7/29/19		0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



Container No: S209379



Part: RB6872880
Job No: 196895
Serial No/Batch: S209379
Revision: 0
Inspector:
Exp Date:
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Date: 08/27/19

Part Specifications
Specifications could not be found.

Plex 6/24/19 12:53 PM Dart.Guerin.Kimberley



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PURCHASE ORDER

POHB043785



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938.

Attention: Ana
(541) 780-6938.

Ship To:

PO No: POHB043785
PO Date: 6/19/19
Due Date: 7/29/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No.	Item No.	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	196847	RB6872201P			Prop Flange Puller	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$2,048.20/Ea	\$2,048.20
2	196848	RB6891198P			Wrench	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$1,441.15/Ea	\$1,441.15
3	196849	RB6796966P	RB6796966P		RET. RING, FUEL CTR. DR. PLIER	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$827.00/Ea	\$1,654.00
4	196851	RB6795614P			Puller/Pusher Idler Gear Support Shaft	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$538.00/Ea	\$1,076.00
5	196852	RB6795984P			Power Turbine Holder Shaft	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$721.00/Ea	\$1,442.00
6	196853	RB6872550P			Compressor Rotor Coupler Adapter Holder	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$1,063.00/Ea	\$2,126.00
7	196854	RB23033037P			Holder Compressor Rotor Coupling Adapter	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$1,408.85/Ea	\$1,408.85
8	196855	RB6798981P			Prop Shaft Splined Adapter	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$1,207.45/Ea	\$1,207.45
9	196856	RB6795644P			Bearing Nut Wrench	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$1,387.95/Ea	\$1,387.95



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10	196857	RB6795588P			Wrench-Holding, 32/64 Pitch 24 Tooth Spline	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$910.00/Ea	\$1,820.00
						2x	AUG 0 2 2019						
11	196858	RB23005022P	RB23005022P		INR. PWR. TURB. SHFT. MANDREL	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$1,645.40/Ea	\$1,645.40
						1x	AUG 0 2 2019						
12	196859	RB6795637P			Adapter	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$894.00/Ea	\$1,788.00
						2x	JUL 3 0 2019						
13	196860	RB6895528P			Rear Compressor Bearing Pusher	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$772.35/Ea	\$772.35
						1x	JUL 3 0 2019						
14	196861	RB6796949P			Accessory Gear Box Bearings Installation Drift	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$292.00/Ea	\$584.00
						2x	JUL 3 0 2019						
15	196862	RB6796948P			Drift Install/Removal Accessories Gear Box	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$310.00/Ea	\$620.00
						2x	JUL 3 0 2019						
16	196863	RB6872881P	RB6872881P		COMPR MTG INSERT WRENCH	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$327.00/Ea	\$654.00
						2x	JUL 3 0 2019						
17	196864	RB6798986P			Prop Shaft Bearing Puller Plate	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$720.10/Ea	\$720.10
						1x	JUL 3 0 2019						
18	196866	RB6798983P			Prop Shaft Assembly Drift	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$209.00/Ea	\$209.00
						1x	JUL 3 0 2019						
19	196867	RB6796946P			Install & Removal Accessory Gear Box Bearings Drift	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$353.00/Ea	\$706.00
						2x	JUL 3 0 2019						
20	196868	RB6795990P			Dummy Bearing Power Turbine Shaft Front	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$304.00/Ea	\$304.00
						1x	JUL 3 0 2019						
21	196869	RB6795993P			Joining And Separating Power	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$389.50/Ea	\$389.50
						1x	JUL 3 0 2019						



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Items													
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22	196870	RB23034275P			Adapter Pilot Rear Compressor Bearing Puller	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$340.00/Ea	\$340.00
							1 X JUL 30 2019						
23	196871	RB6798980P			Shaft Spanner Nut Wrench	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$1,479.15/Ea	\$1,479.15
							1 X JUL 30 2019						
24	196872	RB6798845P			Turbine 2Nd Stage Spline Adapter	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$1,038.35/Ea	\$1,038.35
			PS				1 X JUL 30 2019						
25	196873	RB6872746P			Puller, Power Train Drive Gear Bearing	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$1,950.00/Ea	\$3,900.00
							2 X AUG 02 2019						
26	196874	RB6893361P			Power Turbine Coupling Inner Race Puller	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$1,071.60/Ea	\$1,071.60
							1 X AUG 02 2019						
27	196875	RB6872927P	RB6872927P		RED. GEAR FLANGED STUD WRENCH	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$340.64/Ea	\$681.28
							2 X JUL 30 2019						
28	196876	RB6872477P			Spanner Power Turbine Coupling Inner Nut Wrench	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$579.50/Ea	\$579.50
			PS-				1 X JUL 30 2019						
29	196877	RB6872202P			Prop Shaft Support Fixture	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$503.50/Ea	\$503.50
							1 X JUL 30 2019						
30	196878	RB6795597P			Spanner Wrench	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$649.00/Ea	\$1,298.00
							2 X AUG 07 2019						
31	196882	RB6796941P			Seals Replacement, Accessories Gear Box	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$4,053.00/Ea	\$8,106.00
			PS				2 X JUL 30 2019						
32	196883	RB6798838P			Gas Producer Turbine Tie Bolt	Firmed	-	8/16/19	2 Ea	0 Ea	2 Ea	\$691.00/Ea	\$1,382.00
							2 X AUG 02 2019						
33	196884	RB6796918P			Install Turbine & Exh Collet Support Oil Bellows Seal Dft	Firmed	-	8/16/19	2 Ea	0 Ea	2 Ea	\$877.00/Ea	\$1,754.00
							AUG 02 2019 2 X AUG 07 2019						



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Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance		
34	196885	RB6795594P			Fixture-Assembly, Compressor Rotor	Firmed	-	8/16/19	1 Ea	0 Ea	1 Ea	\$1,519.00/Ea	\$1,519.00
							1X JUL 30 2019						
35	196886	RB23033029P			Fixture Alignment Compressor Rotor Front	Firmed	-	8/16/19	1 Ea	0 Ea	1 Ea	\$3,962.50/Ea	\$3,962.50
							1X AUG 2 2 2019						
36	196887	RB6895995-4P			Fixture-Alignment Compressor Rotor (2 Piece)	Firmed	-	8/16/19	1 Ea	0 Ea	1 Ea	\$347.70/Ea	\$347.70
							1X AUG 0 2 2019						
37	196888	RB6887819P			Gas Producer & Power Turbine Supports Bearing Bore Checking Fixt	Firmed	-	8/16/19	1 Ea	0 Ea	1 Ea	\$1,711.34/Ea	\$1,711.34
							1X AUG 2 0 2019						
38	196889	RB6872162P			Sump Assembly Pressure Test Fixture	Firmed	-	8/16/19	1 Ea	0 Ea	1 Ea	\$928.62/Ea	\$928.62
							1X AUG 0 2 2019						
39	196890	RB6798925P			Gas Producer 2Nd Stage Wheel Locknut Crimper	Firmed	-	8/16/19	2 Ea	0 Ea	2 Ea	\$1,410.00/Ea	\$2,820.00
							2X AUG 2 0 2019						
40	196895	RB6872880P			Compressor Mounting Inserts Checking Fixture	Firmed	-	8/16/19	2 Ea	0 Ea	2 Ea	\$1,905.00/Ea	\$3,810.00
							1X AUG 2 7 2019						
41	196892	RB6796930P			Accessory Gear Box Install Plate	Firmed	-	8/16/19	2 Ea	0 Ea	2 Ea	\$841.00/Ea	\$1,682.00
							2X AUG 2 0 2019						
42	196893	RB23006778P	RB23006778P		GUIDE SPUR ADAPTER GEAR SHAFT	Firmed	-	8/16/19	3 Ea	0 Ea	3 Ea	\$427.00/Ea	\$1,281.00
			PS				3X JUL 3 0 2019						
Grand Total:												\$64,199.49	



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Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 7/30/19 3:41 PM dart.belanger.natasha



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 675

Date: 8/26/2019
PO Ref: HB043785
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty
2

Item
COMPRESSING MOUNTING INSERTS
CHECKING FIXTURE

Part No.
RB6872880 REV. A

RECEIVED

AUG 27 2019

DART AEROSPACE LTD.

Received by:

Packaged by: AUP

Checked by: Q.E.

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: HB043785

Dated: 8/26/2019

Our Order / Job No: AWT- HB043785 A40

Order Qty: 2

Part Name: COMPRESSOR MOUNTING INSERTS CHECKING FIXTURE

Part Number RB6872880

DAS
40
9-89

Lot Size: N/A

Ship Date: 8/23/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RB6872880

Rev: A

Material Size and Type: -1/ STEEL; -2/DOM STEEL

Material Specifications: STEEL: ASTM A36; DOM STEEL: ASTM A513

Heat Treatment: 51.0 RC

Plating/Finish: NICKEL PLATE: .0004 - .0006

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date:

8/26/19

Signed:

Hemant M. Patel

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com

CONTROLLED DOCUMENT

SHOP COPY

JUL 25 2016

JOB NUMBER

0-50

FILE COPY

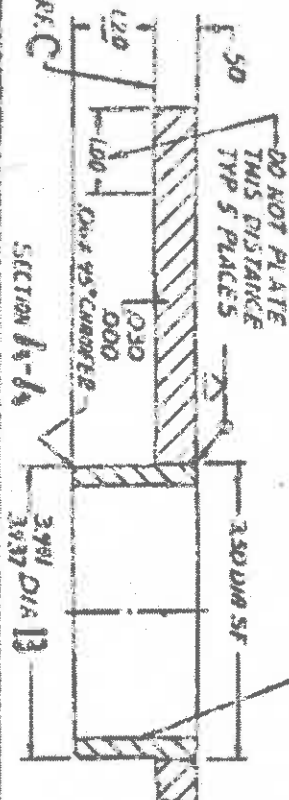
ALL INFORMATION CONTAINED HEREIN IS UNCLASSIFIED
(a) THE NAME ALLISON FOLLOWED BY
(b) THE TOOL NO. AND LAST CHG LTR
(c) VENDOR NAME OR TRADEMARK

NO.	AS ORIGINATE	Y ORIGINATE
1	2.90	5.02
2	.98	3.62
3	5.02	2.90
4	3.75	.22
5	6.52	2.83
6	1.54	3.42
7	1.42	4.38
8	2.60	2.70
9	5.17	1.85
10	3.51	1.29

BRIGHT NICKEL PLATE ITEMS (AND 2
EXCEPT DIA) AND FIVE PLACES ON
SURFACE (AS SHOWN) PER MIL STD-208,
FINISH IN P-102 (REF QQ-N-290, TYPE II
BRIGHT FINISH; DIM MUST
BE MET AFTER PLATING. PLATING
THICKNESS TO BE .0006 MIN COPPER
AND .0006 MIN NICKEL.

SURFACE CANNOT BE SQUARE WITH
DIM 13 WITHIN .005 TIE
SURFACE OUTSIDE 800 DIA MUST BE
FLAT WITHIN .005 TOTAL

BEZEL SWAMP EDGES .020 UOS



1 STEEL SHAFTS
CARD HARDEN & BOILING OIL
NORMALIZE

2 3.50 DIA X .25 WALL
STEEL TUBING
1 REOD

QTY	DESCRIPTION	UNIT	PRICE
1	STEEL SHAFTS	EA	1.00
1	STEEL TUBING	EA	1.00
1	BEZEL SWAMP EDGES	EA	1.00
1	FIXTURE - CHECKING	EA	1.00
1	COMP. MTG INSERTS (CLEARBOX)	EA	1.00

QTY	DESCRIPTION	UNIT	PRICE
1	STEEL SHAFTS	EA	1.00
1	STEEL TUBING	EA	1.00
1	BEZEL SWAMP EDGES	EA	1.00
1	FIXTURE - CHECKING	EA	1.00
1	COMP. MTG INSERTS (CLEARBOX)	EA	1.00

6872880